

Rush

Ship DEC 2

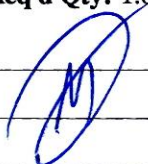
Work Order ID 153902

153902

Page 1

Monday, November 28, 2016 2:22:53 PM

Item ID: D2842-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Assembly RH, 206 Float
 Start Date: 11/28/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/1/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan:  Date: 11-28 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2842

Rev C

100

0.00

100

Large Fab

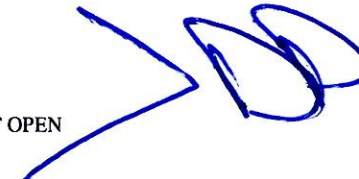
Large Fab

Memo

0.12

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
 2-Drill D2842-1 using Jig DT8272 as per Dwg D2842 ***DO NOT OPEN HOLES***
 3-Deburr and bevel ends for welding

 16-11-29
DAS
18
9-89

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Memo

0.00

Quality Control

1 16-11-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 153902

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Item ID: D2842-042 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 11/28/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/1/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Large Fab	Weld per dwg A/R Aluminum rod Batch: <i>m133750</i> Large Fab	0.00							
Large Fab	Memo 1-Weld one end cap and (2) lugs using DT10058 as per Dwg D2842 2- OPEN HOLES TO SIZE AS PER DWG (0.250") 3-Grind end cap weld flush	0.15							
				<i>BE 16-11-30</i>					
				<i>BE 16-11-30</i>					
				<i>BE 16-11-30</i>					
120 *120* QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							DAS 9 9-89
Quality Control	Memo	0.00				<i>①</i>	<i>16-11-30</i>		
130 *130* QC	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
Quality Control	Memo	0.00				<i>①</i>	<i>16-11-30</i>		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

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NS1

***NS?**

Reference:

NR1

NR2

**Insp.
Stamp**

1-Remove alodine prior to welding.
Weld end cap as per Dwg D2842.
2-Grind end cap weld flush.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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							Lead hand / Supervisor Approval Verification 		
							QC / QA Coordinator Approval 		

Root Cause			FAULT CATEGORY								
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 153902

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Item ID: D2842-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Assembly RH, 206 Float
Start Date: 11/28/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/1/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00				①	16-12-01		DAS 9 9-89
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00				①	16-12-01		DAS 9 9-89
Quality Control									
185	Pressure Wash per QSI005 4.3	0.00							
185									
HandFinish	Memo	0.03				(x1)			
Hand Finishing	***Touch up step with alodine per qsi 005 prior to powder coat***							2016/12/05	BEE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY								
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 153902

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Item ID: D2842-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Assembly RH, 206 Float
Start Date: 11/28/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/1/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 135418</i> Memo START TIME: <i>10:45</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>11:15</i>	0.00 0.03				<i>1</i>	<i>0</i>	<i>16-12-05</i>	<i>3300</i>
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>IRM of all 16/12/05</i>
210 *210* HandFinish Hand Finishing	HandFinishing Memo 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: <i>M135819</i>	0.00 0.16				<i>(X1)</i>	<i>0</i>	<i>2016/12/06</i>	<i>BEB</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 153902

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Item ID: D2842-042 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 11/28/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/1/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC5- Inspect part completeness to step on W/O	0.00							
220									DAS 38 9.89
QC	Memo	0.00							DEC 06 2016
Quality Control									
230	Identify as per dwg & Stock Location: _____	0.00							
230									
Packaging	Memo	0.00							Sms 16/12/16
Packaging									
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.02							16/12/16
Quality Control									

DAS
21
9.89

DEC 06 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Picklist Print

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Work Order ID: 153902

153902

Parent Item: D2842-042

D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 11/28/2016

Required Date: 12/1/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

NAS1149C0332R

Purchased

No

100

Each

3,950.000

3

3

NAS1149C0332R

WASHER

Location

Loc Qty

Loc Code

FP001

432

m135672

120

m135948

312

GA

86

m133284

86

ST260a

2500

m135466

1000

m136042

500

m136199

1000

ST266

932

m135408

232

m135766

500

m135908

200

**

BE3 2016/12/06

D2622-120C

Manufactured

No

110

Each

65.0000

1

1

D2622-120C

Step Extrusion

Location

Loc Qty

Loc Code

WA003

65

150070

65

**

DD 16-11-28

1

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Picklist Print

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Work Order ID: 153902

153902

Parent Item: D2842-042

D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 11/28/2016

Required Date: 12/1/2016

Start Qty: 1.00

Required Qty: 1.00

D2734 Manufactured No 110 Each 91.0000 2
D2734
Step End Plate

**

DP 16-11-28

Location	Loc Qty	Loc Code
WA003	91	
149392	91	

D3459-1 Manufactured No 110 Each 28.0000 2
D3459-1
Float Step Mounting Plate

**

DP 16-11-28

Location	Loc Qty	Loc Code
WA003	28	
134950	8	
146920	20	

D3459-3 Manufactured No 210 Each 29.0000 2
D3459-3
Float Step Mounting Plate

**

DP 16-11-28

Location	Loc Qty	Loc Code
WA003	29	
130491	5	
146785	24	

MS27039C1-07 Purchased No 210 Each 125.0000 3
MS27039C1-07
screw

**

3
BEB 2016/12/06.

Location	Loc Qty	Loc Code
ST277	125	
m131624	42	
m132317	83	

3

Monday, November 28, 2016 2:23:00 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER :			

Picklist Print

Monday, November 28, 2016 2:23:00 PM

Work Order ID: 153902

153902

Parent Item: D2842-042

D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 11/28/2016

Required Date: 12/1/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1329C3KB130

Purchased

No

**M131677*3*

Each

67.0000

3

3

NAS1329C3KB130

Insert

BEB 2016/12/06

Location

Loc Qty

Loc Code

ST261

67

m132551

20

m132767

15

m132803

12

m133483

20

NAS1515H3L

Purchased

No

210

Each

135.0000

3

3

***NAS1515H3I ***

Washer

BEB 2016/12/06

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

91

m127831

20

m134508

3

m135600

68

ST266

4

m130726

4

x3

DQA: _____ Date: _____



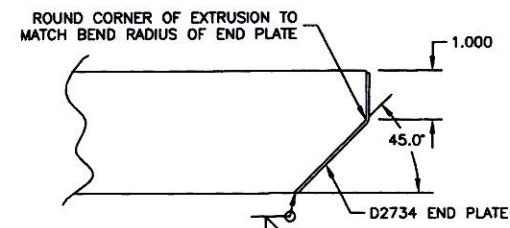
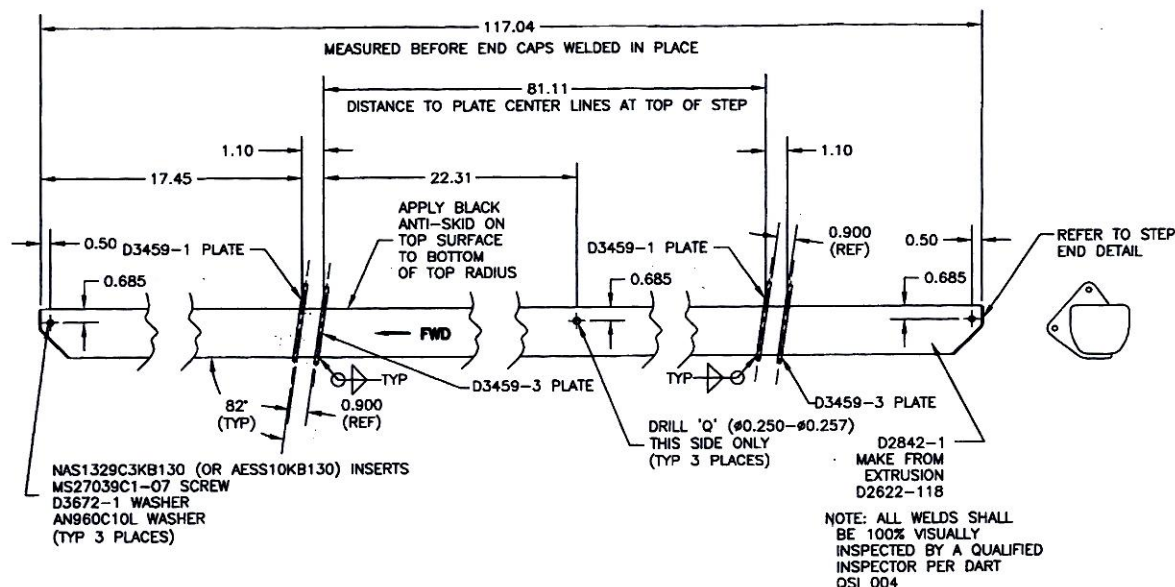
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Qty -041	Qty -042	Part Number	Description
X	X	D2842-041	LH FLOAT STEP ASSEMBLY
		D2842-042	RH FLOAT STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	D3672-1	WASHER
3	3	MS27039C1-07	SCREW
3	3	NAS1149C0332R	WASHER (AN960C10L)
3	3	NAS1329C3KB130	INSERT (or AESS10KB130)



TYPICAL STEP END DETAIL
NOT TO SCALE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 153902
16-11-28

D2842-041 LH FLOAT STEP ASSEMBLY (SHOWN)
D2842-042 RH FLOAT STEP ASSEMBLY (OPPOSITE)

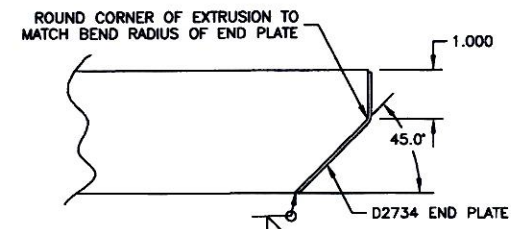
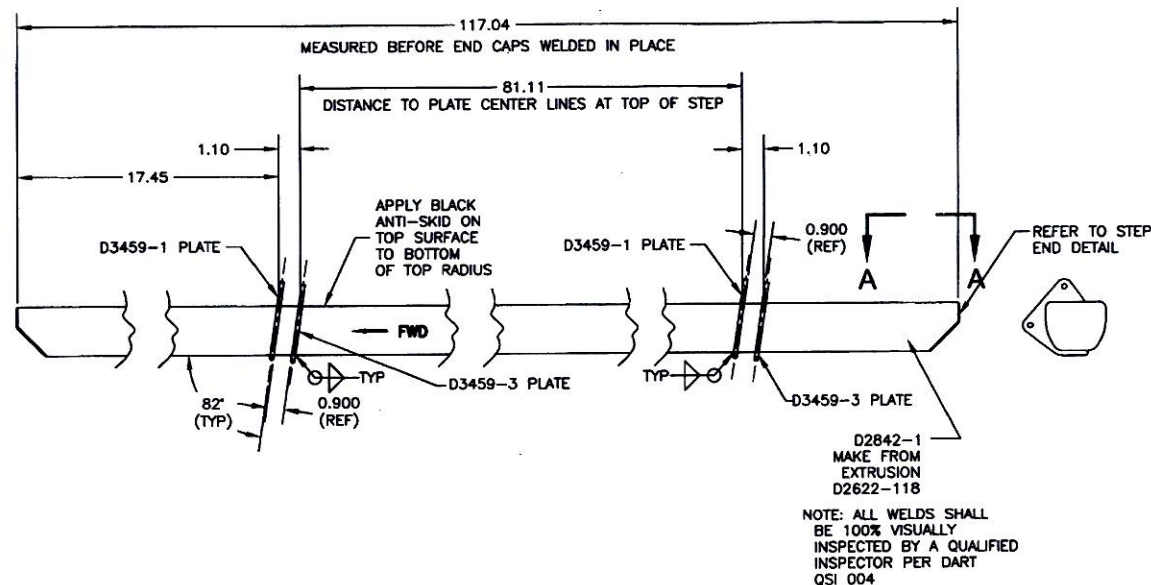
NOTES:

- 1) MATERIAL: MAKE FROM EXTRUSION D2622
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2842-041/-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

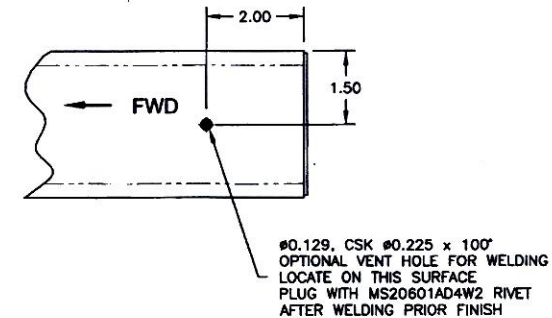
RELEASED
2016-08-02
EN 4-420

C	ADD -043/-044 (FOR PHI) FORMATTED TO CURRENT STANDARD	DS	16.04.25
B	RE-DESIGN, ADD D3459-1/-3	PH	98.10.13
A	NEW ISSUE	KE	98.10.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC	
DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. C
MFG. APPR.	DD	D2842	SHEET 1 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.		206/407 FLOAT STEP ASSEMBLY	NTS
DATE	16.04.25	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Qty -043	Qty -044	Part Number	Description
X		D2842-043	LH FLOAT STEP ASSEMBLY (FOR PHI)
	X	D2842-044	RH FLOAT STEP ASSEMBLY (FOR PHI)
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
1	1	MS20601AD4W2	RIVET



TYPICAL STEP END DETAIL
NOT TO SCALE



SECTION A-A
NOT TO SCALE

D2842-043 LH FLOAT STEP ASSEMBLY (SHOWN)
D2842-044 RH FLOAT STEP ASSEMBLY (OPPOSITE)

NOTES:

- 1) MATERIAL: MAKE FROM EXTRUSION D2622
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME (REF 4.2.1.3.3) OUTSIDE PER QSI 005 4.2.1
PAINT BLACK PER QSI 005 4.2.2 USING CA8213/F37038 CAMOFLAGE BLACK PER MIL-PRF-05285E TYPE I CLASS H
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2842-043/044" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

RELEASED
2016-08-02

DESIGN	KE	DART AEROSPACE USA, INC	
DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. C
MFG. APPR.	DD	D2842	SHEET 2 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.		206/407 FLOAT STEP ASSEMBLY	NTS
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